



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4956-15
Job Sheet 173005



Part No: D4956-15

Job Qty: 8 ea

Part Name: Wearplate Fwd



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/23/18

Job Tracking No:

Due Date: 3/5/18

Created By: Logan David

Type: Stock

Description:

Note: DWG REV A SHEETS 2,8 IPP REV:A 14.04.22 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea		3/3/18	0.00	0.00	Start Up Waterjet		
100	Waterjet	8 pcs		3/3/18	0.00	1.56	Waterjet1		DAS
120	QC	8 pcs		3/3/18	0.00	0.00	QC8		38
130	Brake NC	8 pcs		3/3/18	0.33	0.33	Brake NC 1		9-89
140	QC	8 pcs		3/3/18	0.00	0.00	QC5		21
150	HandFinish	8 pcs		3/5/18	0.00	0.33	HandFinish4		21/04/2018 JLD
160	QC	8 pcs		3/5/18	0.00	0.00	QC3		11 APR 23 2018
170	Packaging	8 pcs		3/5/18	0.00	0.00	Packaging3-2		9-89
180	QC21-SA	8 Ea		3/5/18	0.00	0.00	QC21		DAS 21 9-89 APR 23 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S20GA ROCK GUARD 138854	304/316, 040 Sheet	7.6000 sf (.95 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S20GA	8	169	0



Container No: S057047



Part: D4956-15

Job No: 173005

Serial No/Batch: S057047

Revision:

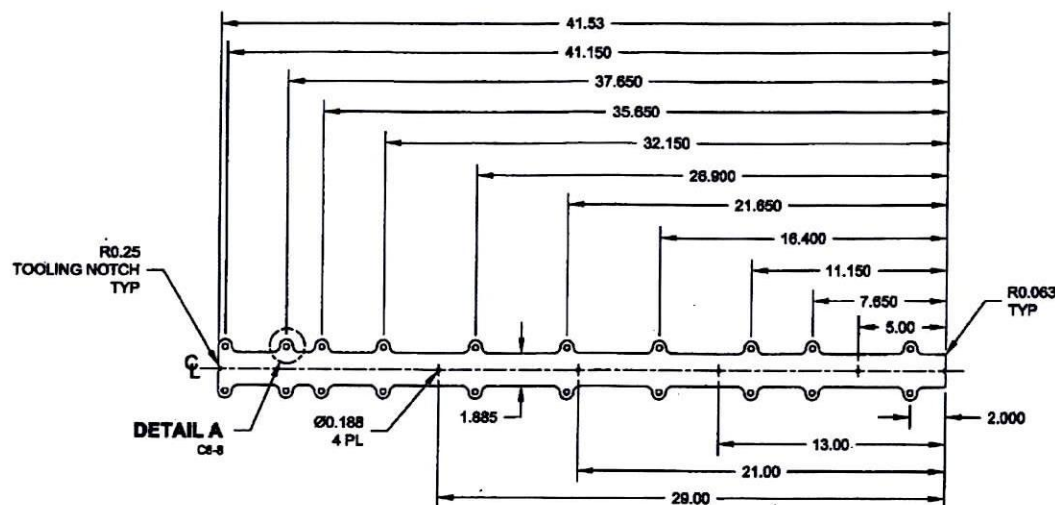
Inspector:

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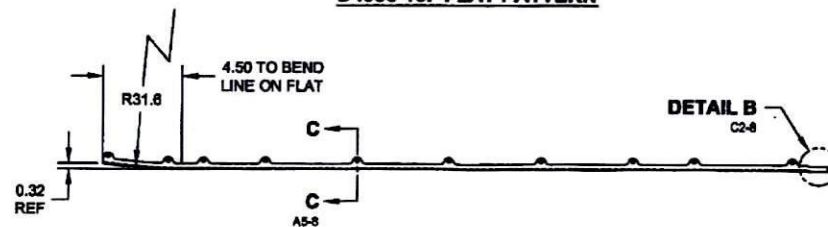
Date: 03/29/18

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearshoe	0.188Inches + 0.005 - 0.001	0.193 0.187	Diameter	
2	Wearshoe	0.300Inches ± 0.010	0.310 0.290		
3	Wearshoe	0.300Inches ± 0.010	0.310 0.290		
4	Wearshoe	2.000Inches ± 0.010	2.010 1.990		
5	Wearshoe	5.000Inches ± 0.030	5.030 4.970		
6	Wearshoe	7.650Inches ± 0.010	7.660 7.640		
7	Wearshoe	41.150Inches ± 0.010	41.160 41.140		
8	Wearshoe	13.000Inches ± 0.030	13.030 12.970		
9	Wearshoe	16.400Inches ± 0.010	16.410 16.390		
10	Wearshoe	21.000Inches ± 0.030	21.030 20.970		
11	Wearshoe	21.650Inches ± 0.010	21.660 21.640		
12	Wearshoe	26.900Inches ± 0.010	26.910 26.890		
13	Wearshoe	29.000Inches ± 0.030	29.030 28.970		
14	Wearshoe	32.150Inches ± 0.010	32.160 32.140		
15	Wearshoe	35.650Inches ± 0.010	35.660 35.640		
16	Wearshoe	37.650Inches ± 0.010	37.660 37.640		
17	Wearshoe	41.150Inches ± 0.010	41.160 41.140		
18	Wearshoe	41.530Inches ± 0.030	41.560 41.500		

Plex 2/23/18 2:36 PM dart.logan.david



D4956-15F FLAT PATTERN



D4956-15 WEARSHOE
(MAKE FROM D4956-15F)

NOTES

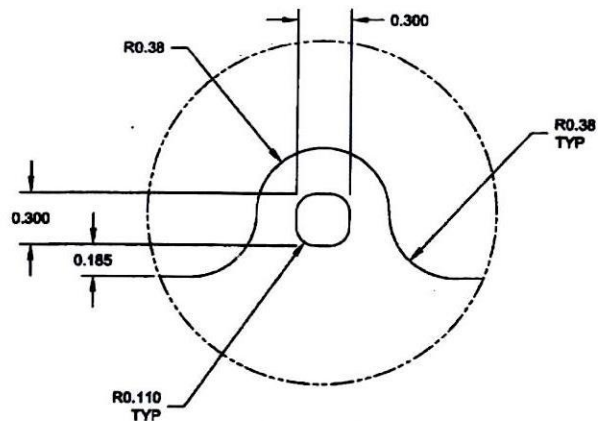
- 1) MATERIAL: AISI 304/316 SS SHEET, 0.038 THICK (20 GAUGE)
PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240
REF DART: SPEC M304S20GA
- 2) FINISH: COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020-0.040 THICK, PER DART QSI 005 4.9
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: 0.95 lbs
- 8) SYMMETRY: ABOUT CENTERLINE

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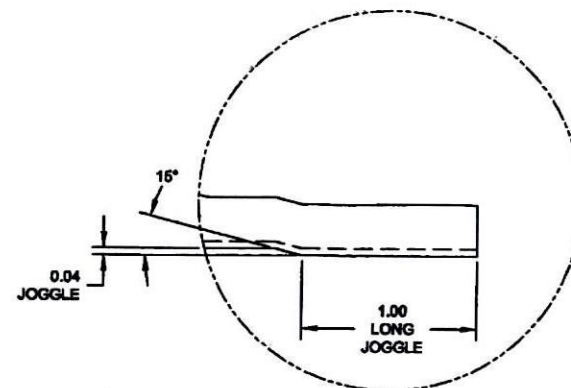
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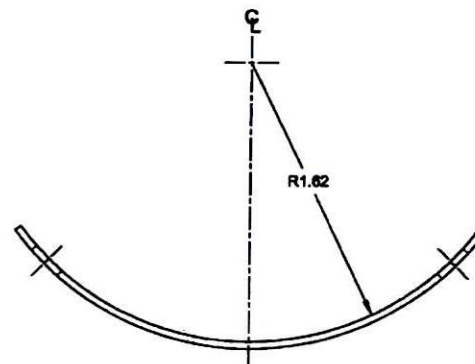
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C8-2 C1-3
C8-3 C1-3
C2-4
C8-5 C2-5
C8-6 C2-6
C4-7 C3-7



DETAIL B B6-1 B2-1
B3-2
B5-3 B1-3
B2-4
B4-7 B1-7



SECTION C-C B7-1 B3-1
B5-2
B7-3 B3-3
B6-4
B7-5 B3-5
B7-6 B3-6
B7-7 B3-7

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